

order 8651 11 Oct



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

005562

D206-642-414
Job Sheet 183234



Part No: D206-642-414 **Job Qty:** 1 ea
Part Name: Skidtube RH,High Gear with Run-on Landing Wearplates



Part Weight: 0 lbs **Status:** Scheduled **Priority:** Medium
Job Created: 9/13/18 **Job Tracking No:**
Due Date: 10/11/18 **Created By:** Marie Lajeunesse
Type: SOLD **Description:**

Note: DWG REV Q SHEETS 31-32 IPP REV:A 11.11.18 NEW ISSUE DD VERF:JFS IPP REV:B 13.06.28 IIN-D206-642 rev.p DD VERF:JFS IPP REV:C 14.04.25 AS PER ECN14-520 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/11/18	10/11/18	0.00	0.00	Start Up Stores/Pkg-1		SEP 20 2018
110	Packaging	1 pcs	10/11/18	10/11/18	0.00	0.00	Packaging1-2		SEP 20 2018
120	QC	1 pcs	10/11/18	10/11/18	0.00	0.00	QC4		
125	DC	1 pcs	10/11/18	10/11/18	0.00	0.00	DC		
130	Packaging	1 pcs	10/11/18	10/11/18	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea	10/11/18	10/11/18	0.00	0.00	QC21		

Part Op 110 - Pick Kit
Descriptions: 120 - QC4- 100% Inspect kits for completeness
125 - Document Control Photocopy bluefile and create labels per PPP D206-642-414 CHG001
130 - Identify as per dwg & Stock Location: _____ Identify and pack for shipping as per PPP D206-642-414
Location: _____ PPP Rev: _____
140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-41A	Bolt	8 Ea (8 ea)	90-Start up Operation	S038750
AN4-6A	Bolt	12 Ea (12 ea)	90-Start up Operation	S089455
AN4C5A	Bolt	1 Ea (1 ea)	90-Start up Operation	S019407
AN5-11A	Bolt	8 Ea (8 ea)	90-Start up Operation	S003927
AN5-12A	Bolt	4 Ea (4 ea)	90-Start up Operation	S003926
AN5-13A	Bolt	4 Ea (4 ea)	90-Start up Operation	S014743
D206-642-451	Replacement Skidtube,High Gear with Run-on Landing Wearplates Fits LH or RH	1 Ea (1 ea)	90-Start up Operation	S.H.5517
D206-648-013	Ground Handling Wheel Modification	1 Ea (1 ea)	90-Start up Operation	S103186
D2652	Bushing	16 Ea (16 ea)	90-Start up Operation	S092682
D2712	Set Screw	10 Ea (10 ea)	90-Start up Operation	S031303

S115517x1x1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																											
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																																																									
Description		Disposition																																																																																											
 Container No: S112105 Part: D206-642-414 Job No: 183234 Serial No/Batch: S112105 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: TC STC SH98-4 Issue 2-6-88/STC SA00475SE 15/10/28, EASA STC		 DART Aerospace Ltd. 1270 Aberdeen Street Heskethbury, ON K6A 1K7 CANADA TEL: 1 813 632-6200 Email: sales@dartero.com www.dartaerospace.com																																																																																											
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		Lead hand / Supervisor Approval Verification																																																																																											
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OTHER : _____																																																																																													

D2932-2	Saddle RH Out, 206	1 Ea (1 ea)	90-Start up Operation	509 975 4
D2933-2	Saddle RH In, 206	1 Ea (1 ea)	90-Start up Operation	509 783 4
D2934	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	505 458 4
D2935	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	505 458 2
D2938-2	Saddle RH Out, 206	1 Ea (1 ea)	90-Start up Operation	510 127 1
D2939-2	Saddle RH In, 206	1 Ea (1 ea)	90-Start up Operation	50 98 39 4
D3407-043	Tow Ring	1 Ea (1 ea)	90-Start up Operation	50 592 8 4
D3413-1	O-Ring	1 Ea (1 ea)	90-Start up Operation	50 592 8 4 B165886
D3456-1	Washer	1 Ea (1 ea)	90-Start up Operation	50 793 35
D3457-1	Washer	2 Ea (2 ea)	90-Start up Operation	503 543 3
MS21042L3	Nut	8 Ea (8 ea)	90-Start up Operation	50 893 40
MS21042L4	Nut	12 Ea (12 ea)	90-Start up Operation	509 459 2
MS21043-4	Nut	1 Ea (1 ea)	90-Start up Operation	508 927 7
NAS1149C0463R Washer		1 Ea (1 ea)	90-Start up Operation	505 395 3
NAS1149D0363J Washer		8 Ea (8 ea)	90-Start up Operation	506 866 1
NAS1149D0463J Washer		24 Ea (24 ea)	90-Start up Operation	508 929 9
NAS1149D0563J Washer		8 Ea (8 ea)	90-Start up Operation	509 377 3

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-41A	8	139	0
	AN4-6A	12	1,151	0
	AN4C5A	1	59	0
	AN5-11A	8	109	0
	AN5-12A	4	368	0
	AN5-13A	4	66	0
	D206-642-451	1	1	0
	D206-648-013	1	8	0
	D2652	16	419	0
	D2712	10	605	0
	D2932-2	1	8	0
	D2933-2	1	10	0
	D2934	2	60	0
	D2935	2	74	0
	D2938-2	1	9	0
	D2939-2	1	8	0
	D3407-043	1	18	0
	D3413-1	1	35	0
	D3456-1	1	216	0
	D3457-1	2	57	0
	MS21042L3	8	3,308	0
	MS21042L4	12	4,202	0
	MS21043-4	1	1,125	0
	NAS1149C0463R	1	335	0
	NAS1149D0363J	8	2,285	0
	NAS1149D0463J	24	7,424	0
	NAS1149D0563J	8	1,684	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

4.6 206L/L-1/L-3/L-4 HIGH GEAR SKIDTUBES

ITEM	QTY -411	QTY -412	QTY -413	QTY -414	QTY -441	QTY -457	QTY -449	QTY -451	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-411	SKIDTUBE INSTALLATION, LH
		X								D206-642-412	SKIDTUBE INSTALLATION, RH
			X							D206-642-413	SKIDTUBE INSTALLATION, LH
				X						D206-642-414	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-441	SKIDTUBE
						X				D206-642-457	WEARSHOE KIT (REPLACES -447)
							X			D206-642-449	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-451	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-7	SKIDTUBE ASSEMBLY
1								1		D4361-043	SKIDTUBE ASSEMBLY
2A					22			10		D2651-1	* PLUG ⁽¹⁾
2B					22			10		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-13A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D4956-15	WEARSHOE (REPLACES D3535-15 + D3536-15)
23A					1	1				D4956-23	WEARSHOE (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-37	WEARSHOE (REPLACES D3535-37 + D3536-37)
26A					60	60				MS27039C1-08	SCREW
26B					60	60				NAS1149D0332J	WASHER (OR AN960JD10L)
26C					60					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40								2		D3414-041	LUG ASSEMBLY (REPLACES D2659)
41								4		AN3C37A	BOLT
42								8		D2652	BUSHING
43								4		MS21043-3	NUT
44								4		NAS1149C0363R	WASHER (OR AN960C10)

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Revision: Q

Date: 13.08.12